



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-133
Job Sheet 175684



Part No: D350-591-133

Job Qty: 10 ea

Part Name: AFT Maintenance Step, Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/10/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG DSI9712 REV A, IIN-D350-591 REV H, D2946 REV B IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		7/4/18	0.00	0.00	Start Up Large Fab-4		D.M.L 18-6-8
110	Large Fab	10 pcs		7/5/18	0.00	6.96	Large Fab 8		D.M.L 18-6-8
120	QC	10 pcs		7/5/18	0.00	0.00	QC6		18-06-12
130	Large Fab	10 pcs		7/5/18	0.00	6.96	Large Fab 2		18-06-13
140	QC	10 pcs		7/5/18	0.00	0.00	QC9		18-06-14
150	QC	10 pcs		7/5/18	0.00	0.00	QC5		18-06-14
160	HandFinish	10 pcs		7/5/18	0.00	1.52	HandFinish1		SA 18-06-15
170	QC	10 pcs		7/5/18	0.00	0.00	QC7-2		18-06-15
180	Large Fab	10 pcs		7/5/18	0.00	6.96	Large Fab 2		18-06-18
190	QC	10 pcs		7/5/18	0.00	0.00	QC10		CPC
200	QC	10 pcs		7/5/18	0.00	0.00	QC5		EPL
210	HandFinish	10 pcs		7/5/18	0.00	1.52	HandFinish1		18-06-19
220	Powdercoat	10 pcs		7/5/18	0.00	1.04	Powdercoat1		18-6-21
230	HandFinish	10 pcs		7/6/18	0.00	1.52	HandFinish3		18-6-21
240	QC	10 pcs		7/6/18	0.00	0.00	QC3		18-6-21
250	Packaging	10 pcs		7/6/18	0.00	0.00	Packaging1-3		18-6-21
260	QC	10 pcs		7/6/18	0.00	0.00	QC4		18-6-21
265	DC	10 pcs		7/6/18	0.00	0.00	DC		18-6-21
270	Packaging	10 pcs		7/6/18	0.00	0.00	Packaging3-1		18-6-21
280	QC21-FG	10 Ea		7/6/18	0.00	0.00	QC21		18-6-21

Part Op 110 - 1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946

Descriptions: 130 - 1-Deburr and Bevel ends for welding Use DT8440 jig

180 - Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush.

220 - START TIME:

265 - Photocopy bluefile and type labels as per PPP D350-591-133 CHG004

270 - Identify and pack for shipping as per PPPD350-591-133 Location:FG038

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	5.2000 Ea (.52 ea)	90-Start up Operation	5046116
D2734	Step End Plate	20 Ea (2 ea)	130-Large Fab	5063695 → 10, 5071383 → 1
D2944	Step Mounting Plate	20 Ea (2 ea)	130-Large Fab	5077402
AN4-11A	Bolt	40 Ea (4 ea)	250-Packaging	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>175684</u> Part No. <u>D350-591-133</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☒</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☒	Composite ☐	Supplier ☐	
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Date: <u>18-06-18</u>		Step #: <u>180</u>		QTY Effective: <u>10</u>		MRB (QSI042) Approval <u>INS</u> <u>12</u> <u>18/6/17</u>																	
Description Work Order Deviation				Disposition																			
<u>Top View</u> <u>Ø0.129, CSK Ø0.225 X 100°</u> <u>OPTIONAL VENT HOLE</u> <u>FOR WELDING LOCATE</u> <u>ON SURFACE RUG WITH</u> <u>MS20601AD4W2 RIVET</u> <u>AFTER WELDING, PRIOR</u> <u>TO FINISH</u> <u>MS20601AD4W2</u> <u>B# 505894</u> Qty <u>19x</u>				<u>Acceptable.</u>				Completed By 															
				Lead hand / Supervisor Approval Verification DAS <u>9</u> <u>9-89</u> <u>18-06-18</u>																			
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Root Cause		FAULT CATEGORY																					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	☒ Fit/Function	Misread ☐																		
Substation ☐	☒ Process Improvement	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																		
Past Expiry Date ☐	Manufacturing Process ☐																						
Misidentified ☐	Past Due ☐	OTHER: _____																					

AN4-16A	Bolt	80 Ea (8 ea)	250-Packaging
AN4-7A	Bolt	20 Ea (2 ea)	250-Packaging
D2230-1	Mounting Lug	40 Ea (4 ea)	250-Packaging
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging
D2732	Rubber Cushion (\$Per Foot)	20 Ea (2 ea)	250-Packaging
D2945	Mounting Plate	10 Ea (1 ea)	250-Packaging
D3338-1	Mounting Lug	10 Ea (1 ea)	250-Packaging
MS21042L4	Nut	140 Ea (14 ea)	250-Packaging
NAS1149D0463J	Washer	140 Ea (14 ea)	250-Packaging

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	5	195	0
130-Large Fab	D2734	20	9	0
	D2944	20	6	0
250-Packaging	AN4-11A	40	138	0
	AN4-16A	80	212	0
	AN4-7A	20	216	0
	D2230-1	40	4	0
	D2230-3	40	155	0
	D2732-030	xs 20 each	509	0
	D2945	10	23	0
	D3338-1	10	33	0
	MS21042L4	140	3,623	0
	NAS1149D0463J	140	5,583	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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 Hawkebury, ON K6A 1K7
 CANADA
 TEL: 905-632-6200
 Email: sales@dartaero.com
 www.dartaerospace.com



Container No: S079334

Part: D350-591-133

Job No: 175684

Serial No/Batch: S079334

Revision:

Inspector:

Exp Date: 06/08/2018

Instructions:

Handling/Pre

Material

Internal Transport

Tribal Knowledge

LOA

Substation

Past Expiry Date

Misidentified

Training

Use for Testing

Poor Information

Rushing

Product Improvement

Process Improvement

Manufacturing Process

Past Due



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004017	S017090	AN4-11A	Bolt		ST344	12
004017	S083330	AN4-11A	Bolt	s070193	ST344	28
004017	S080645	AN4-16A	Bolt		ST343	26
004017	S083273	AN4-16A	Bolt	S080645	ST343	38
004017	S083282	AN4-16A	Bolt	S080645	ST343	1
004017	S083292	AN4-16A	Bolt	S080645	ST343	2
004017	S083318	AN4-16A	Bolt	S083292	ST343	2
004017	S083320	AN4-16A	Bolt	S082909	ST343	11
004017	S083338	AN4-7A	Bolt	s057520	ST345	20
004017	S083352	D2230-1	Mounting Lug	S065887	ST521	40
004017	S083372	D2732-030	Rubber Cushion - 3"	S073491	ST410	80
004017	S054561	D2945	Mounting Plate	S054561 x 9	ST014	10 x S078919 x 1
004017	S083246	MS21042L4	Nut	S067898	ST303	140
004017	S083245	NAS1149D0463J	Washer	s067900	ST263	140

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

004017

D2945

S078919

x1.

Plex 6/23/18 7:06 AM dart.quirion.sonia

D2230-13 S085090 x40 SN

D3338-1 S026722 x10

2

Part Number: D350-591-133

Description: AFT MAINTENANCE STEP (FITS LH or RH)

[illegible]